

Date: Thursday, 31/07/2008 12:18:52 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP LH (FOLDING)
 Job Number : 40857
 Estimate Number : 12567
 P.O. Number :
 This Issue : 31/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412630033
 First Issue : // Type : LARGE FAB ASSY Drawing Number : IIN D412-630
 Previous Run : 40268 Project Number : N/A
 Drawing Revision : L
 Material :
 Due Date : 25/08/2008 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. Rev:A New Issue 06-11-08 JLM
 est rev B ecn 1019, added d2807-041 EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile & create labels per PPP D412-630-033 CHG003

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

Batch

B33585 x4 40274 x1

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	

Batch

35826 x4

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	

Batch

40278

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch: 35751

AS 08/08/07 (x5)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

34020

AS 08/08/07 (x5)

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-041

Step Weldment LH

B41245

AS 08/09/02 (x5)

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

33578

AS 08/08/07 (x5)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

101189

AS 08/08/07 (x5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

106340 x11 M106375 x9

AS 08/08/07 (x5)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108618 x4 M108672 x16

AS 08/08/07 (x5)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

AS 08/08/07 (x5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

AS 08/09/02 (x2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/09/02 (x2 LH)

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-1

Description

Bushing

Batch

35630

JS 08/09/02 (12)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

B34019

JS 08/09/02 (12)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

4629

JS 08/09/02 (12)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

34025

JS 08/09/02 (12)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M107242

JS 08/09/02

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M101189

JS 08/09/02 (K2)

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M107082

JS 08/09/02 (K2)

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C7A	Eyebolt	M100446

JS 08/09/02 (K2)

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M105125

JS 08/09/02 (K2)

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M108558

All same batch and was it

JS 08/09/02 (K2)

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description
7 NAS1515H5 Washer

Batch

M108334

AS 08/09/02 (2)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description
4 MS21043-4 Nut

Batch

M108472

AS 08/09/02 (2)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description
3 MS21043-5 Nut

Batch

M108583

AS 08/09/02 (2)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/02 (2)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

A

8/9/02

50

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/02 (2)

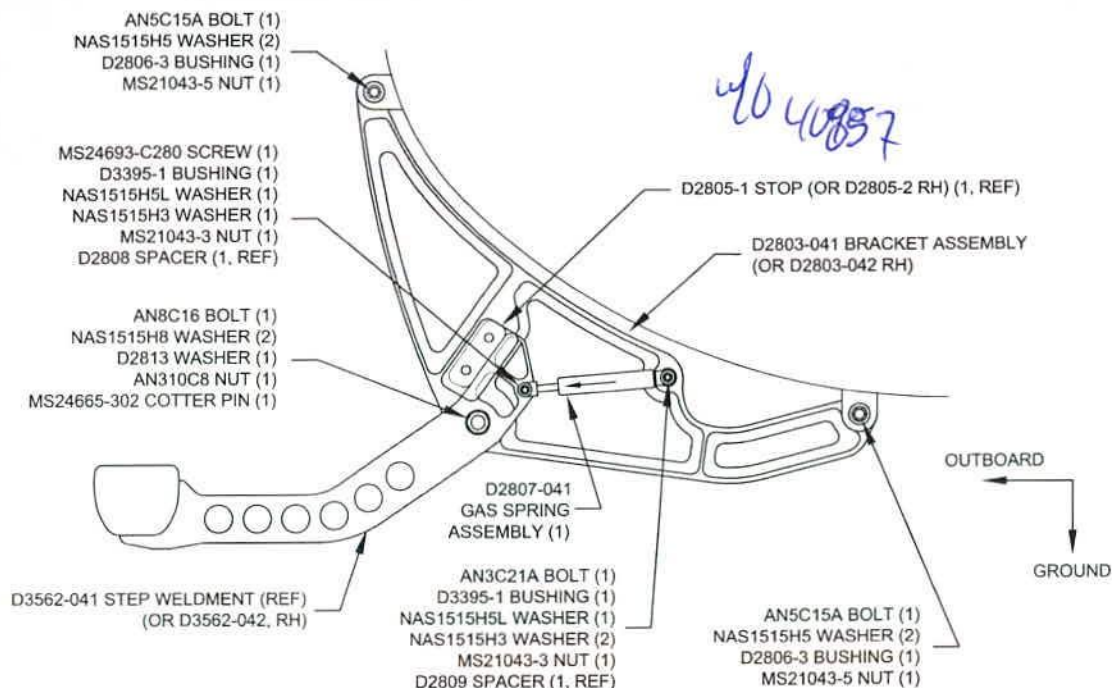
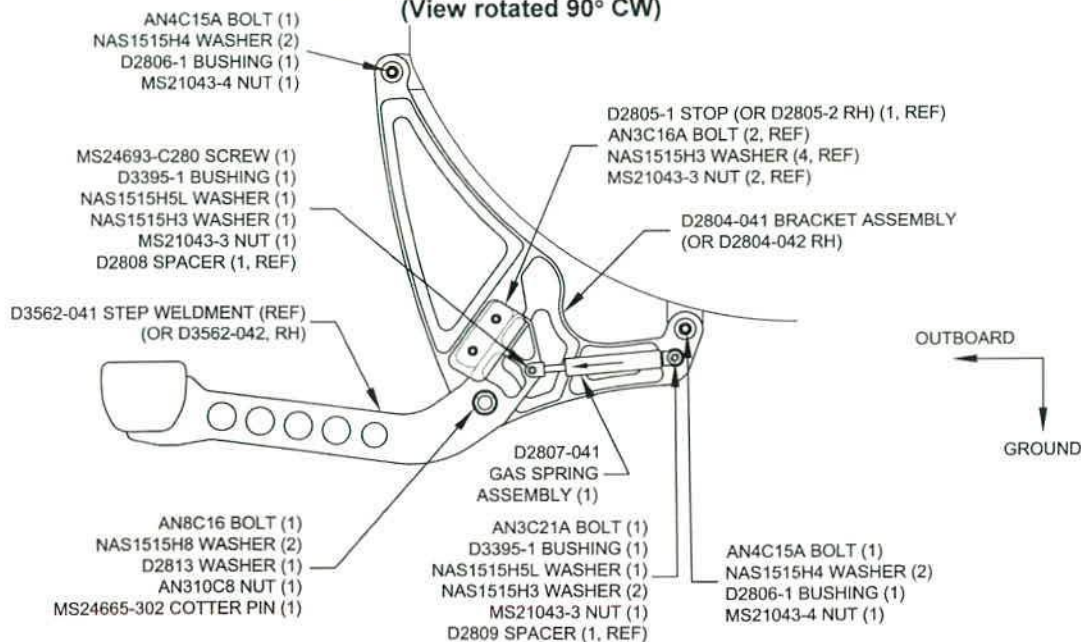
Job Completion



W 08/09/02

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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RETURN TO
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WORK ORDER
NO. 46851

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)

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25-00-00